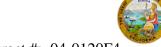
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 1.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-000349 Address: 333 Burma Road **Date Inspected:** 10-Aug-2007

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1500 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: American Bridge/Fluor Enterprises, a JV **Location:** Benicia, CA

**CWI Name: CWI Present:** Yes No Jesse Cayabyab **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS: Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** Procedure Qualification Plate (PQR) Test

### **Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/Flour (ABF) for the purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Companys Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Jesse Cayabyab, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

The QA Inspector observed welding being performed on a non-PQR test plate that was tacked in the 1G position onto the same fixture as the actual PQR test plate known as ABF-PQR-025-1A (high heat). This will be the second attempt to weld this PQR plate. Mr. Cayabyab checked welding amperage, voltage and travel speed parameters while the depositing weld metal onto the non-PQR test plate. The QC Inspector and the welding operators agreed that welding parameters were capable of producing sound weld. The non-PQR test plate was removed and the QA Inspector observed the root pass being deposited on PQR test plate using .072 inch diameter (1.8mm) Hobart Fabshield XLR-8 flux-cored arc welding (FCAW-S) process and utilizing a Bug-O Systems mechanical device that travels on a magnetic track. Welder Dan Gordon deposited (6) further weld passes. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated on this date.

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)



# **Summary of Conversations:**

The QC Inspector informed the QA Inspector the final passes on this PQR plate would begin the start of shift on the following Monday.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	White, Danny	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer